

Work Order ID 81761

Friday, March 16, 2012 3:37:17 PM

81761Ship April 4th
Page 1

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Base Assembly, 350
Start Date: 3/20/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/30/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: *MF* Date: *12-03-16* Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A
D4020	A

100 Weld per dwg A/R S.S. rod Batch: *118366* 0.00
100 Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

Pl 12.04.03 1x Ø

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

12.04.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1 BL 124-41

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT: START TIME: 10h30 OVEN TEMPERATURE: 400°F FINISH TIME: 11h00 ***** 2nd coat if necessary*****								
	2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

1 0 2P 12/04/09

1 BL 12-4-4

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/20/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/30/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

150

Assemble as per dwg

0.00

150

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

1 BR 12-4-4.

SP 12-04-04

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

87644

170

Identify as per dwg & Stock Location: D4030-CH 0.00

0.000

170

Packaging

Memo

0.00

Packaging

81753

1 ~~PR~~ 15.7.4.

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept

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Revision ID:

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Stop ***NS2***

Start Date: 3/20/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/5
MF
12-04-04

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Picklist Print

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
verified by:EC

IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	23.0000	2	3A3		12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		23							
				69739		1							
				70766		2							
				77045		1							
				77523		19			B81253 (2)				
D3913-1 Rib		Manufactured	No			100	Each	1.0000	1	3A0		12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		1							
				78039		1			81196 (1)				
D3913-15 Wide Handle Plate		Manufactured	No			100	Each	11.0000	1	3A0		12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		11							
				78321		1							
				80778		10			(1)				
D3913-3 Rib		Manufactured	No			100	Each	5.0000	1	3A0		12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		5							
				69160		1							
				78287		4							
D3913-7 Rib		Manufactured	No			100	Each	6.0000	2	3A0		12-03-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		6							
				79416		6			B81439 (2)				

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Work Order ID: 81761

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-9 Manufactured No 100 Each 2.0000

Hinge Rib

1 SAD 12-03-30

Location Loc Qty Loc Code

WA006 2

70138 1

79876 1

B80791

①

D3916-041 Manufactured No

Rib Assembly

100 Each 8.0000

2 SAD 12-03-30

Location Loc Qty Loc Code

WA006 8

69161 2

79909 6

B81444

②

D3916-5 Manufactured No

Light Rib

100 Each 8.0000

3 SAD 12-03-30

Location Loc Qty Loc Code

WA006 8

79908 8

B81434

③

D4016-1 Manufactured No

Hinge Half, Base

100 Each 23.0000

3 SAD 12-03-30

Location Loc Qty Loc Code

WA005 23

75281 4

79413 19

③

D4017-7 Manufactured No

Rib

100 Each 2.0000

1 SAD 12-03-30

Location Loc Qty Loc Code

WA005 2

69730 1

74682 1

B81176

①

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Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-9 Manufactured No
Rib

100 Each 8.0000

2

SAD 12-03-30

Location

Loc Qty

Loc Code

WA

2

79415

2

WA006

6

70341

2

73531

4

B81445

(2)

D4020-11 Manufactured No
End Mesh, Basket

100 Each 10.0000

2

2

12-03-30

Location

Loc Qty

Loc Code

WA035

10

69648

2

78693

8

(2)

D4021-1 Manufactured No
Handle Plate

100 Each 48.0000

3

SAD³

12-03-30

Location

Loc Qty

Loc Code

WA

8

69518

0

74316

0

74946

0

79414

8

WA005

40

80826

22

81433

18

3

D4034-041 Manufactured No
Aft Upper Rib Assembly

100 Each 5.0000

1

SAD¹

12-03-30

Location

Loc Qty

Loc Code

WA006

5

81172

5

B81171

(1)

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Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D4034-043

Manufactured No

100 Each 3.0000

1

Fwd Upper Rib Assembly

1
SAD 12-03-30

Location

Loc Qty

Loc Code

WA006

3

78036

1

78329

2

B81432

33

693.0022

33

33

M304EX0.75-16F

Purchased No

100 sf

Expanded Metal Flat SS

PL 12-04-04

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

693.0020757

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120318

39.8113116

120917

276.99263

11121082 → 33

AN3-10A

Purchased No

150 Each 379.0000

6

6

Bolt

SP

Location

Loc Qty

Loc Code

GA

75

119084

75

ST351

304

117795

4

120873

300

Lex

AN960JD8

NAS1149DN832J

Purchased No

150 Each 0.0000

2

Washer

11121082 m120422
SP 12-04-04.

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Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D2931	Manufactured	No	150	Each	496.0000	2	SP 2
Bumper							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST504	496	
46064	496	

D4021-5	Manufactured	No	150	Each	7.0000	2	2x BS 2 438 SP
Blanking Plate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	7	
73478	7	

MS20600-AD4W3	Purchased	No	150	Each	1,304.0000	2	SP 2
Cherry Rivets							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST321	1171	
111636	36	
117505	6	
117601	27	
118626	602	
120308	500	
WA018	133	
107939	133	

MS21042L3	Purchased	No	150	Each	3,041.0000	6	SP 6
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	3041	
117441	16	
117885	32	
118451	5	
118927	3	
119017	2812	
119075	173	

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Dart Aerospace Ltd

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Start Date: 3/20/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

654.0000

12

WASHER

Location

Loc Qty

Loc Code

ST275

654

117735

37

119225

14

120498

200

120910

200

120986

200

17317

3

¹²
~~m 12/11/12. Sp~~
12-01-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

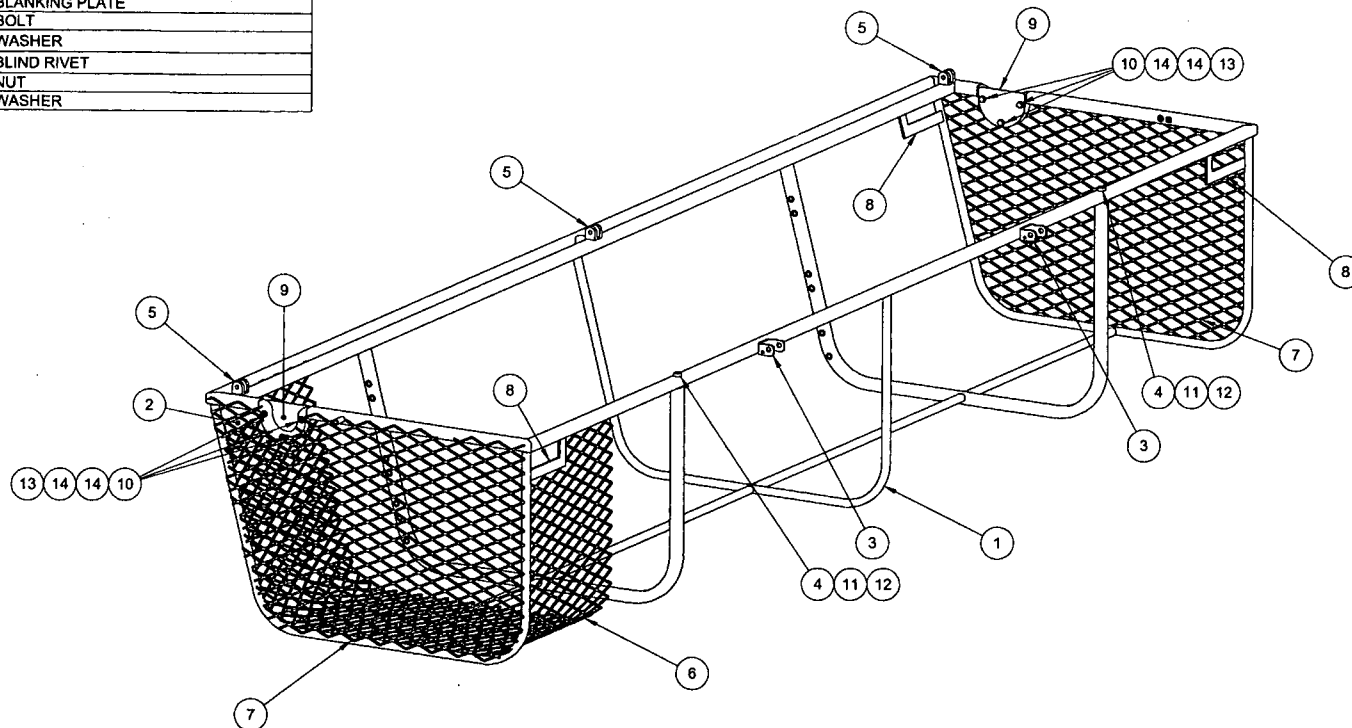
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

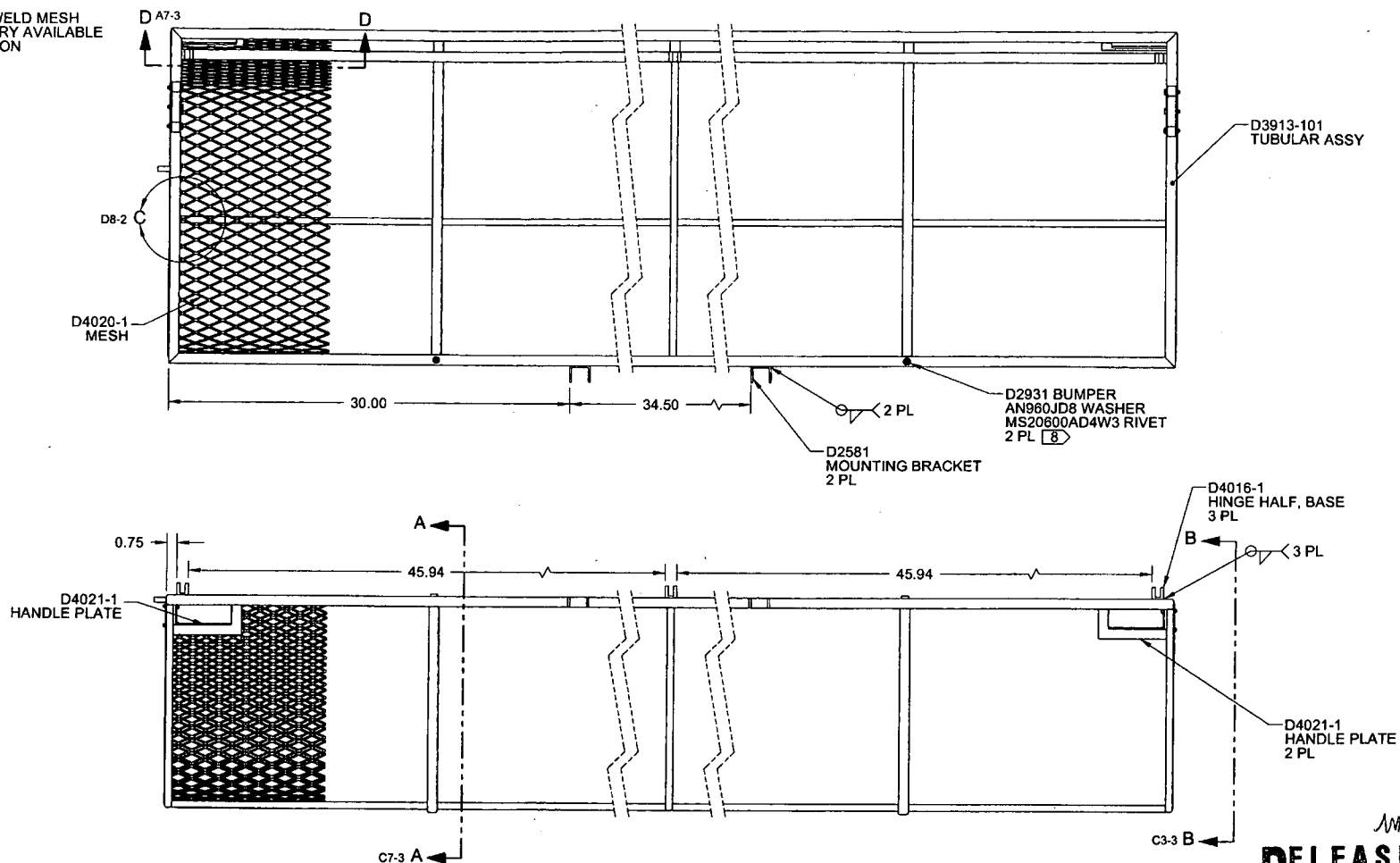
RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. A SHEET 1 OF 6
TITLE LONG BASKET BASE ASSY (350) NTS	
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

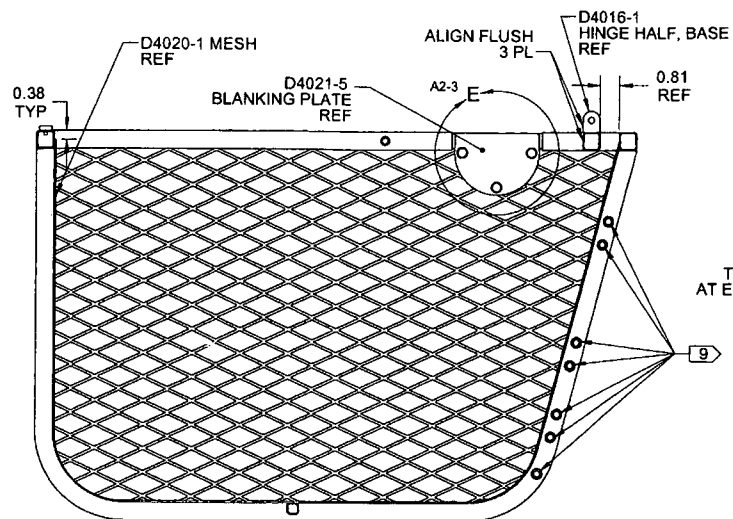
DETAIL C D7-2



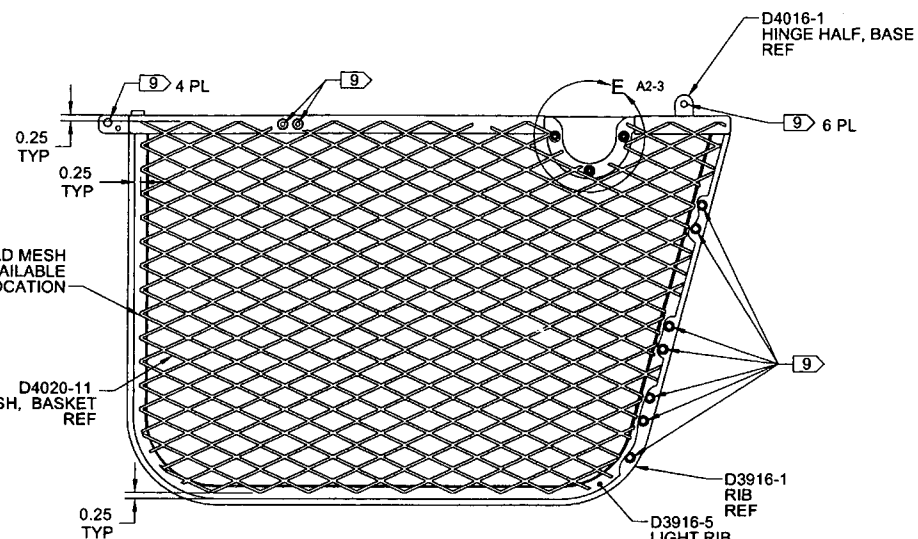
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-09-27

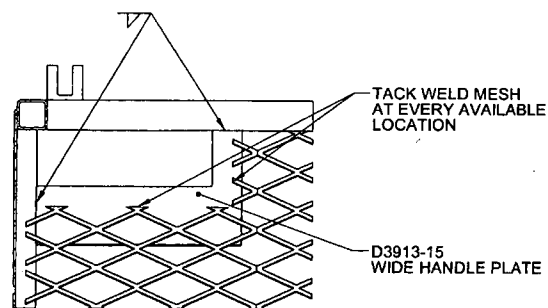
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



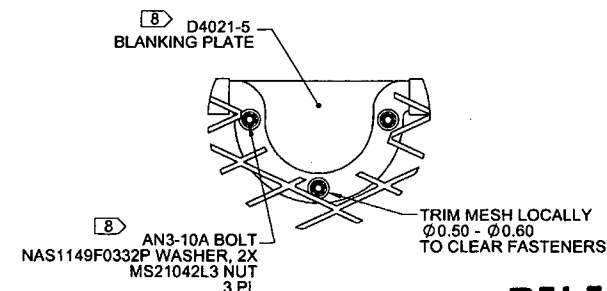
SECTION A-A A5-2



VIEW B-B A2-2







SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

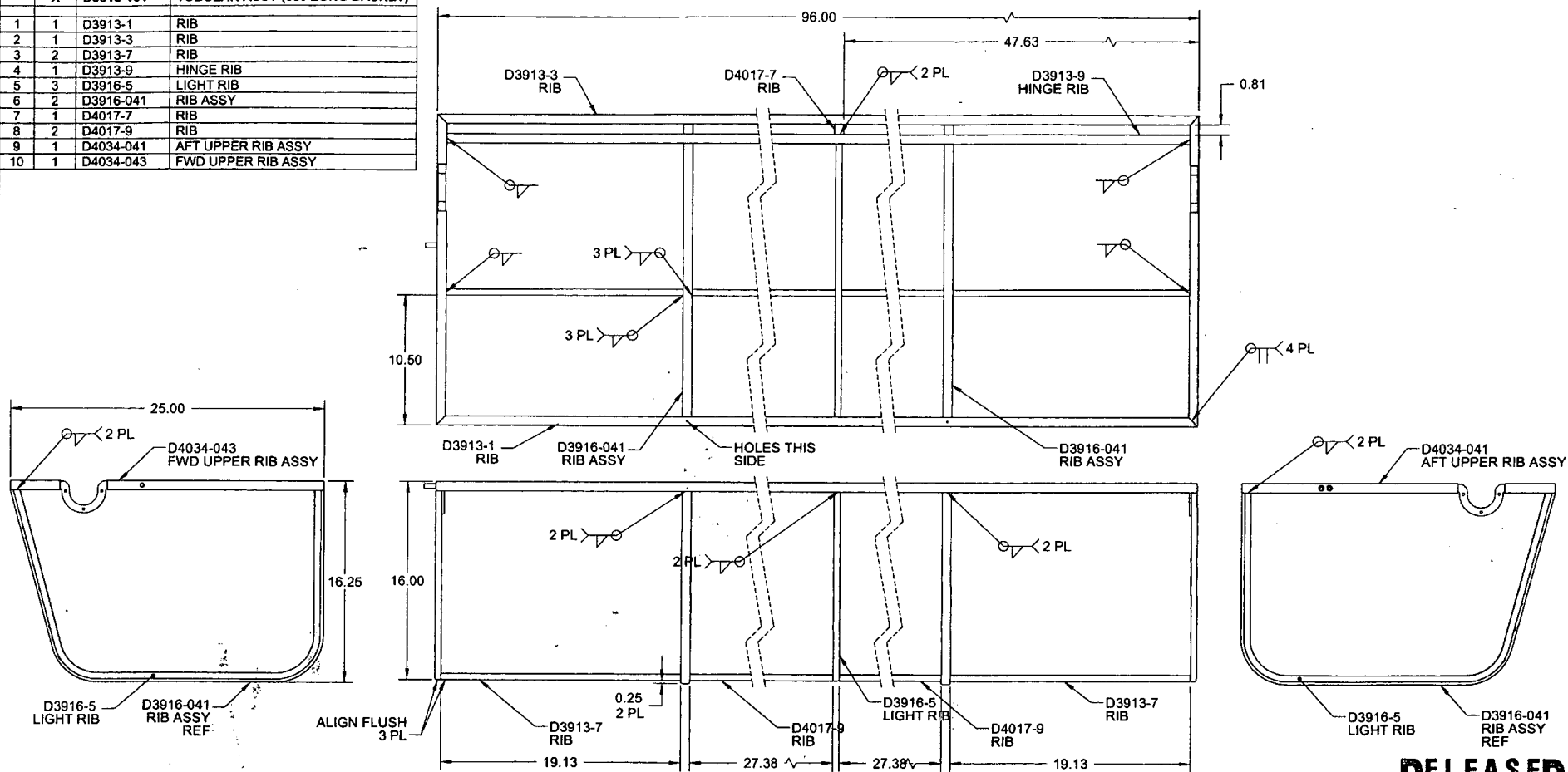
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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2010-03-22

Dart Aerospace Ltd

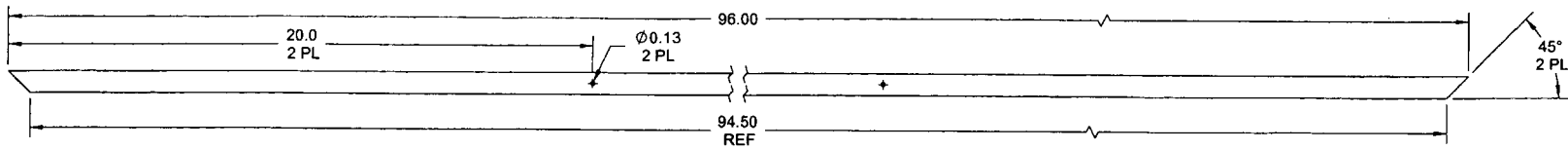
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

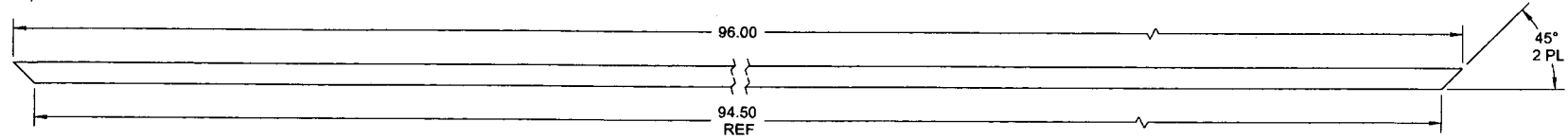
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2010-03-22

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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
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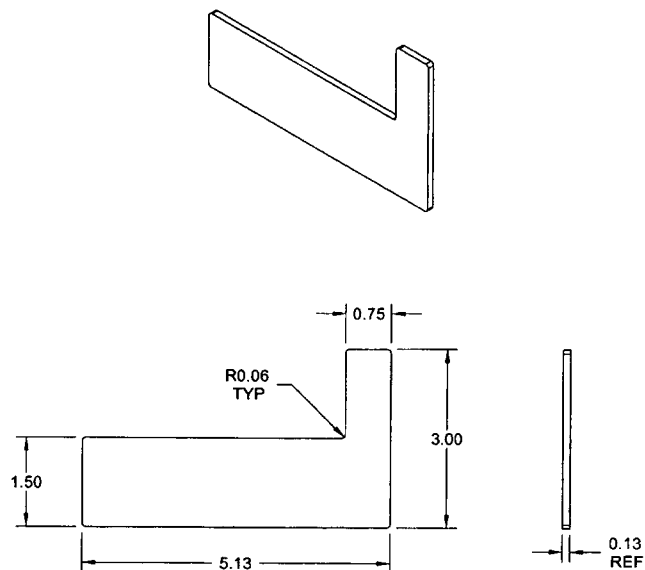
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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2010-03-22

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DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
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